

*** QUALITY ASSURANCE PROVISIONS**

SPECIFICATIONS:

NSN: 3120-01-124-7749 P/N:(78286) 64351-11111-101

NOMENCLATURE: Bushing, Gimbal Ring

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) 64351-11111-101 REV. " B ", PL 64351-11111-101 REV. " C " and all details and specifications referenced therein.

I. QUALITY/INSPECTION REQUIREMENTS

- A.** MIL-I-45208 or ISO 9000 Equivalent applies:
- B.** First Article Testing applies:
- C.** Production Lot Testing applies:
- D.** Mandatory Inspection applies:

II. SUPPLEMENTAL REQUIREMENTS

- A.** Additionally, para. 3.1, 3.5, 5.1, 5.2, 6.1, 6.2 of MIL-Q-9858 or ISO 9000 equivalent applies.
- B.** The contractor shall include on the detailed process operation sheets developed, a tracking method that is traceable to the contract, all in-house manufacturing processes and the identity of all manufacturing sources performing process/operations outside of the contractors facilities. These sheets shall not be revised or altered after the successful completion of FIRST ARTICLE OR PRODUCTION LOT TESTING without the approval from the basic design engineering activity via the P.C.O..
- C.** The inspection method sheets which list the characteristics of each item produced under the contract shall have serial number traceability to the raw material, casting, or forging. The tracking method used on the inspection/method sheets shall be traceable to the contract. In addition, the contractor is responsible for providing completed inspection method sheets showing the actual dimensions taken of all critical characteristics.
- D.** Markings shall be I/A/W MIL-STD-130 REV."K" para 5.3.3(a),(b),(c),(g). Method and location shall be I/A/W the drawing.

III. MANDATORY INSPECTION REQUIREMENTS:

During production, mandatory inspection is required to be accomplished by the contractor as follows:

A. LEVEL OF INSPECTION (L.O.I.)

- 1) Critical Characteristics: 100% inspection and documentation of dimensions taken shall apply
- 2) Major and Minor Characteristics: L.O.I. shall be I/A/W a sampling plan acceptable to the Q.A.R..

B. CRITICAL CHARACTERISTICS FOR:

Sikorsky Aircraft: (78286) 64351-11111-101

- 1) .7500/.7495 Dia.
- 2) Surface "B" shall be perpendicular to Surface "A" within .001

C. MAJOR AND MINOR CHARACTERISTICS:

- 1) Shall be defined by the contractor subject to Q.A.R. concurrence, unless defined on applicable drawings and associated specifications.

IV. Unless expressly provided for elsewhere in this clause, equipment such as **FIXTURES, JIGS, DIES, PATTERNS, TEMPLATES, MYLARS, SPECIAL TOOLING, TEST EQUIPMENT**, or any other manufacturing aid required for the manufacture and/or testing of the subject item will not be provided by the government or any other source and is the sole responsibility of the contractor. The foregoing applies notwithstanding any reference to such equipment or the furnishing thereof that may be contained in any drawing or referenced specification.

FIRST ARTICLE TEST REQUIRED (GOVERNMENT TESTING)

I. First Article Inspection/Test Criteria:

The tests to be performed under the contract approval clause of the contract are:

- A. Dimensional Check 100%
- B. Form/Fit
- C. Identification
- D. Visual: Verification of the overall workmanship
- E. Compliance with drawing, (78286) 64351-11111-101 REV." B ",
PL 64351-11111-101 REV "C" and associated drawings, latest revisions, and
specifications referenced therein.
- F. Packaging and Preservation: Verification that the parts have been preserved and
packaged per the requirements of the contract.
- G. Review documentation as provided under DD 1423 requirements.

In addition to the above tests, the First Articles are to be delivered hereunder shall also be subjected to those tests which will demonstrate that the articles comply with contract requirements.

The contractor shall be responsible for providing necessary parts and repair of the First Article Samples during testing.

II. Samples to be submitted for testing: Quantity: Two (2)

- A. Estimated cost: TBD
- B. Waiver of First Article Testing Requirements may be granted for:
(78286) Sikorsky Aircraft

III. Testing shall be performed at the Government Designated facility listed below:

NADEP Cherry Point (N65923)
F.A.T. Control Center
P.O.C. Annie Thomas
Code: 6.1.523
MCAS Cherry Point, NC 28533

IV. Special Instructions:

- A.** Contractor shall provide Two samples, one sample shall be free from cadmium plating and one sample shall be cadmium plated. Corrosive areas are to be coated with a light preservative.
- B.** Samples may be considered as production items under the contract provided that the samples can be refurbished to ready for issue **(RFI)** condition and that the samples have inspection approval of the cognizant **Q.A.R.** Samples may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.
- C.** Samples will be returned to the contractor if not destroyed in testing
- D.** Estimated Production Lead-Time Schedule:
 - 1. Submission of the First Article samples by the contractor: 90 days
 - 2. Analysis of FAT report and notification to contractor: 45 days
 - 3. Production delivery after First Article acceptance: 150 days
 - 4. Total accumulated calendar days 285 days

NOTIFICATION OF SHIPMENT OF MATERIAL FOR GOVERNMENT TESTING

Fourteen (14) days prior to shipment of First Article Samples, the contractor shall notify the designated test facility, in writing of the anticipated shipping date, with an information copy to the P.C.O.. The contractor shall also arrange for preliminary inspection of test samples by the CAO/QAR.

Upon shipment of First Article Samples, two (2) copies of the Material Inspection and Receiving Report (DD Form 250), bearing the QAR's signature and indication of preliminary inspection, shall be forwarded to the designated test facility. The envelopes shall be clearly marked. **"DO NOT OPEN IN MAILROOM"**.

Within 105 days after receipt of the samples, the test site shall complete testing/evaluation and submit two (2) copies of their test report with conclusions and recommendations to the P.C.O..

Disposition instruction must be provided to NADEP Cherry Point, First Article Coordinator.

PRODUCTION LOT TESTING REQUIREMENTS (GOVERNMENT TESTING)

The material produced under contract shall be accepted by the cognizant CAO/QAR contingent upon the successful completion of these requirements.

I. Production Lot Test Sampling Requirements:

- A.** The cognizant CAO/QAR shall select two (2) items at random from the first production lot produced. In addition the QAR shall select one (1) item at random from each successive lot or portion thereof.
- B.** Production Lot Testing to be completed during production after First Article approval.
- C.** Production Lot samples, 2 ea., samples shall have corrosive areas coated with a light preservative.

II. The tests to be performed under the Production Lot Sample testing provisions of the contract are:

- A.** Compliance with drawing, (78286) 64351-11111-101 REV. " B ", PL64351-11111-101 REV " C " and associated drawings, latest revisions, and specifications referenced therein.
- B.** Dimensional Check 100%
- C.** Visual: Verification of the overall workmanship
- D.** Packaging and Preservation: Verification that the parts have been preserved and packaged per the requirements of the contract.
- E.** Review of documentation as provided under CDRL, DD1423

In addition to the above tests, the Production Lot Samples to be delivered hereunder shall also be subjected to those tests which will demonstrate that the samples comply with contract requirements.

III. Testing Location, Cost and Estimated Lead-time:

- A.** Ship samples/Data to NADEP, Cherry Point, POC: Annie Thomas, Code: 6.1.523
- B.** Shipping container marking: **NON RFI**
- C.** Estimated Cost for Inspection/Test is TBD.
- D.** Estimated Lead-time for Inspection/Test is TBD.

Within fifteen days of completion of Production Lot Testing, the CAO/QAR shall prepare and submit two copies of the test report with conclusions and recommendations to the contracting officer.

IV. Shipment and Distribution of Samples:

- A.** Fourteen (14) days prior to shipment of production lot samples, the contractor shall notify the designated test facility, in writing, of the anticipated shipping date, with an information copy to the P.C.O. . The contractor shall also arrange for preliminary inspection of the test samples by the CAO/QAR.
- B.** Upon shipment of Production Lot Samples, two (2) copies of the Material Inspection and Receiving Report (DD Form 250), bearing the QAR'S signature and indication of preliminary inspection, shall be forwarded to P.C.O. and to the designated test facility. The envelope shall be clearly marked. **"DO NOT OPEN IN MAILROOM"**.
- C.** Samples may be considered as production items under the contract provided the samples can be refurbished to Ready For Issue (R.F.I.) condition and provided the samples have inspection approval of the cognizant CAO/QAR. Samples may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.
- D.** Samples will be returned to the contractor. Disposition instructions must be provided to NADEP Cherry Point First Article Coordinator.
- E.** The designated test facility and the contracting officer shall be notified as to all shipping data applicable to the samples, such as bill of lading number, method of shipment, etc... 14 days prior to shipment.

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Form Approved
MB NO. 0704-0188

G. PREPARED BY	H. DATE	I. APPROVED BY	J. DATE
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8 ESTIMATED
TOTAL PRICE